

Date: Tuesday, 27/03/2007 10:00:53 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 31515		Part Number	: D32931	
Estimate Number	: 11178		Drawing Number	: D3293 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 27/03/2007	S.O. No. : N/A	Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 03/04/2007	
Previous Run	: 29240		Qty:	4	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
		
<b>Comment:</b> Qty.: 1.9177 sf(s)/Unit Total : 7.6709 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3293-1 Batch: <u>M102838</u> <u>ml 07 03 27</u> <span style="margin-left: 100px;">(4)</span>		
		
2.0	WATER JET	FLOW WATER JET
		
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3293 Dwg Rev: <u>A</u> <u>ml 07 03 27</u> <span style="margin-left: 100px;">(4)</span> Prog Rev: <u>A</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
<u>ml 07 03 27</u> <span style="margin-left: 100px;">(4)</span>		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
<u>ml 07 03 27</u> <span style="margin-left: 100px;">(4)</span>		
<b>Comment:</b> SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/03/2007 10:00:53 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31515

Part Number: D32931

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

SB 07/03/27 (4)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

U 07/03/27

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HS

07-03-27 (4)

8.0 POWDER COATING

POWDER COATING



M100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

HS

07-03-27 (4)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 07/03/27 (4)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 07/03/27 (4)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/28 (4)

Job Completion



U 07-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## D3293-1 DOUBLER

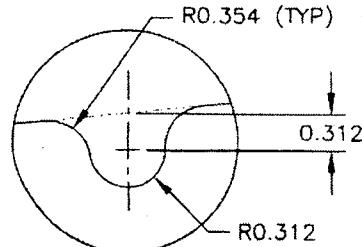
MAKE PER DRAWING FILE "D3293-A1.DWG"  
CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

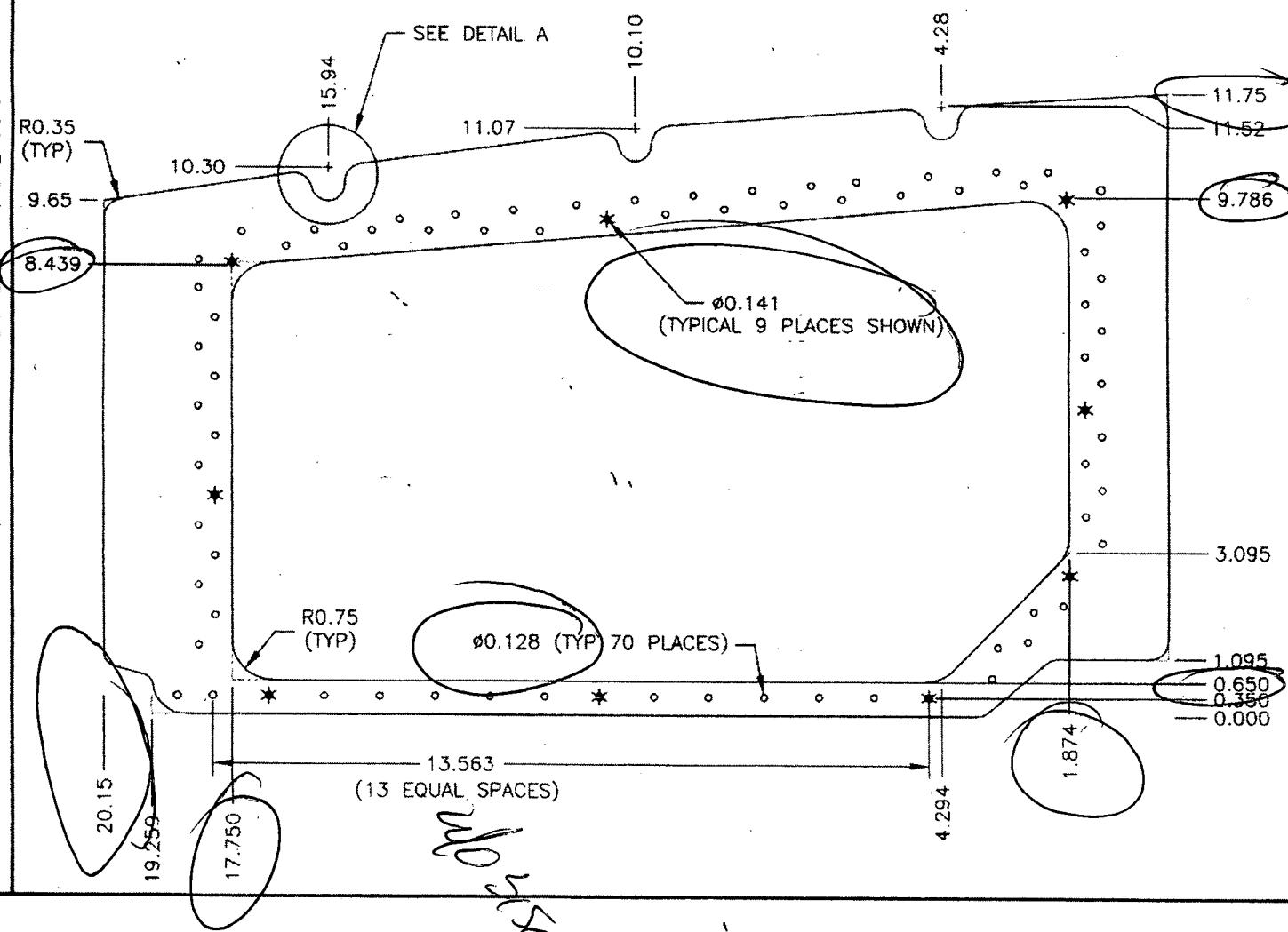
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (REF. 4.3.5.7) PER  
DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL A  
SCALE 2:3

RELEASED  
2006-06-05



**DART**

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2006

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3293
DATE		REV. A
04.06.28		SHEET 1 OF 1
A	04.06.28	SCALE
		1:3
		TITLE
		DOUBLER
		NEW ISSUE

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31515
Description: Doubler	Part Number:	D 3293-1
Inspection Dwg: D 3293 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



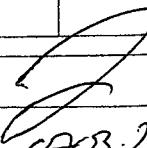
First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.128$	$+/-0.005, 0.001$	0.128	✓		VERN	
B $\phi 0.141$	$+0.005, 0.001$	0.141	✓		VERN	
C $20.15$	$+/-0.030$	20.15	✓		Measuring tape	
D $11.75$	$+/-0.030$	11.73	✓		Measuring tape	
E $1.874$	$+/-0.010$	1.881	✓		VERN	
F $0.650$	$+/-0.010$	0.652	✓		VERN	
G $17.750$	$+/-0.010$	17.750	✓		Measuring tape	
H $8.439$	$+/-0.010$	8.440	✓		VERN	
I $9.786$	$+/-0.010$	9.790	✓		VERN	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M. MM
Date:	07/03/27

Audited by:	
Date:	07/03/27

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	